-Work Ord March-10-14 12			لد	*114	545*						Page 1
Item ID: Revision ID: Item Name:	D3394-3		A	Accept	*N900	<u>040</u>	100)* s	Setup Sta	171	S1* S2*
Start Date: Required Date: Reference:	04/04/2014 30/04/2014	Start Qty: 24.00 Req'd Qty: 24.00	/		Cust Item l Customer:	D:		, · ·			
Approvals:	Process Pla	n:	Date: 1403.10	Tooling: SPC (Y/N):		ate:		R	Run Sta Sto	^ \	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3394 DEO	Rev	В									
101 *101* Purchasing Purchasing		Memo ISSUE PO MAKE PE	TO METEC 233/ R DRWG D3394 REV.B	0.00					(141	03/11	24
102		Receive & Inspect for	Damage & Mat'l Certs	0.00							
100 Packaging Packaging		Memo		0.00				24x		5P14	-3-19
				DAS							
*103 *102* QC		QC6- Inspect dimension	ons to drawing	0.00 9-89	2			24	_		
Quality Control				' 1	1						

i <u>,</u>											
Work Ord		4545		*112	1545*						Page 2
Item ID: Revision ID:	D3394-3			Accept	*N900	040	100	* Se	etup Star	t *N	S1*
Item Name:	Lug								Stop	, *N	S2*
Start Date:	04/04/2014	Start Qty: 24.00	*24*		Cust Item I	D:					
Required Date	e: 30/04/2014	Req'd Qty: 24.00	*24*		Customer:						
Reference:			,								
Approvals:	Process Pla	ın:	Date:	Tooling:	D:	ate:		R	un Star	^I <i>V</i> I	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	, *N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
104		Chemical Conversion Co	at per QSI005 4.1	0.00				2.1	_		
*1 \1 * HandFinish		Мето		0.00				79	M	3/7	3-20

105

QC7-Inspect Chemical Conversion Coat

0.00

105

Hand Finishing

Memo

0.00

Quality Control

φ <u>φ</u> μα

4-7-25

Work Ord		4545		*112	1545*						Page
Item ID: Revision ID: Item Name:	D3394-3 Lug			Accept	*N900	040	100) *	Setup Sta	17	S1* S2*
Start Date: Required Date Reference:	04/04/2014	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item I Customer:	D:				* "N	157"
Approvals:	Process Pla	nn:	Date:	Tooling:	Da	ate:	_]	Run Sta	art *N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	op */	R2*
Sequence ID/ Work Center 1	(D)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
106		Spray Painting per QSI00	05 4.2	0.00							
106 SprayPaint		Memo		0.00				14		<u> </u>	Cl 14
Spray Painting		PRIME B	18927							-	PHO
		delfeet i B <u>12</u> 7	BLUE 671							- \	14
		DEFLEET (B. 125	LEAR 285								•
		PRIME: Start Time:_ Fininsh Tim	<u>7:00</u>								

CA 14-012

Page 3

107 A

50 L

QC14- Inspect Spray Paint

0.00

107

Quality Control

Memo

PAINT: Start Time: 7:45 Finish Time: 9:00

0.00

24 0 0

107B

PPP 117546 (Ulff/25 (24)

DQA:			Date:												
QA Closed:			Date:			WORK ORDER NON-	·CC	NFO		Vork Order u	pdate only	AEROSPACE			
Work Orde	· · ·		v			DISPOSITION			AGAINST D	EPARTMENT	/PROCESS				
Work Orde						Rework 🗡			Skid-tube Crosstube	7	Water-Jet	Engineering			
Part N	lo.					Scrap			Machining Small Fab	Pro	od, Eng. Coor.	Quality			
	•				_	Use-as-is			noforming Finishing		re/Packaging	Other			
NCR N	lo.					Suspected Unapproved			Large Fab Composite		Supplier				
Root					Desci	ription of work order update	1	nitial	Action	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	Date	Verification	n OC Inspector			
Design Doc/Data		14-04	(de		Pain	it thin on ends			scuff + re-point						
Equip/Tooling	\neg		ŀ	x24	20	lug	ļ		dean	20					
Handling/Pre		: ´ 	1	, _ ,		1			DelFleet blue	CR					
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Operator: · · ·									121011	11012	}				
Offset/Setup	t/Setup								Delfleet claus B 125 385						
Process									B 125 385						
Supplier							İ								
Training	*														
Transport															
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Ç4.	Centre Not Concentric			<u> </u>	BOM/Route	<u></u>	Grain	<u> </u>		r tolerance	Set-up				
	_	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardw	-	Part Incorr		Temperature/Cure			
	L	Crimp/Kii	nk/Ripple	e/Wave	<u> </u>	Burrs	<u> </u>	1 '	tion Incomplete/Unqualified	Part Lost/N	_	Weld			
	_	Cuffs			_	Contamination	<u></u>	-	tions Incomplete/Unclear	Part Move		Wrong Stock Pulled			
	<u> </u>	Crushing			\vdash	Countersink	_	4	gned/off center	Positioned	=	[
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislab	<u>-</u>	Power Los	·	Y Other oldly			
	L	Inspectio	•	Tube	\vdash	Drawing	<u> </u>	Misrea		<u>shaped</u>	· port p	ain inthe			
	_	Marks/Ch				Drill Holes	<u> </u>	Off-set	•	<u>~55</u>	to point				
	<u> </u>	Turning S	•		<u> </u>	Finish	_	4	Calibration						
	Wave/Twist in Tube					Fit/Function	1	Out of	Sequence						

Work	Order	ID	114545
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114545

Page 4

March-10-14 12:40:03 PM

Accept *N900040100* Setup Start Item ID: D3394-3 **Revision ID:** Stop **Item Name:** Lug *24* **Start Date:** 04/04/2014 **Start Qty: 24.00 Cust Item ID:** Req'd Qty: 24.00 **Required Date:** 30/04/2014 *24* **Customer:** Reference: Start Run

Approvals: Process Plan: ____ Date: ____ Tooling: ____ Date: ____ SPC (Y/N): ____ Date: ____ Stop *NR2*

Tool ID Tool # Plan Accept Reject Reject Insp. Sequence ID/ Operation Set Up/ Number Code Qty Qty Stamp **Run Hours Work Center ID Description** 0.00 108 QC21- Final Inspection - Work Order Release *108*

Memo 0.00

Quality Control

H14-04-29

Picklist Print

March-10-14 12:43:02 PM

Work Order ID: 114545

114545

Parent Item: D3394-3

D3394-3

Parent Item Name: Lug

Start Date: 04/04/2014

Required Date: 30/04/2014

Page 1

Start Qty: 24.00

Required Qty: 24.00

Comments:

New Issue 11/01/10 LL

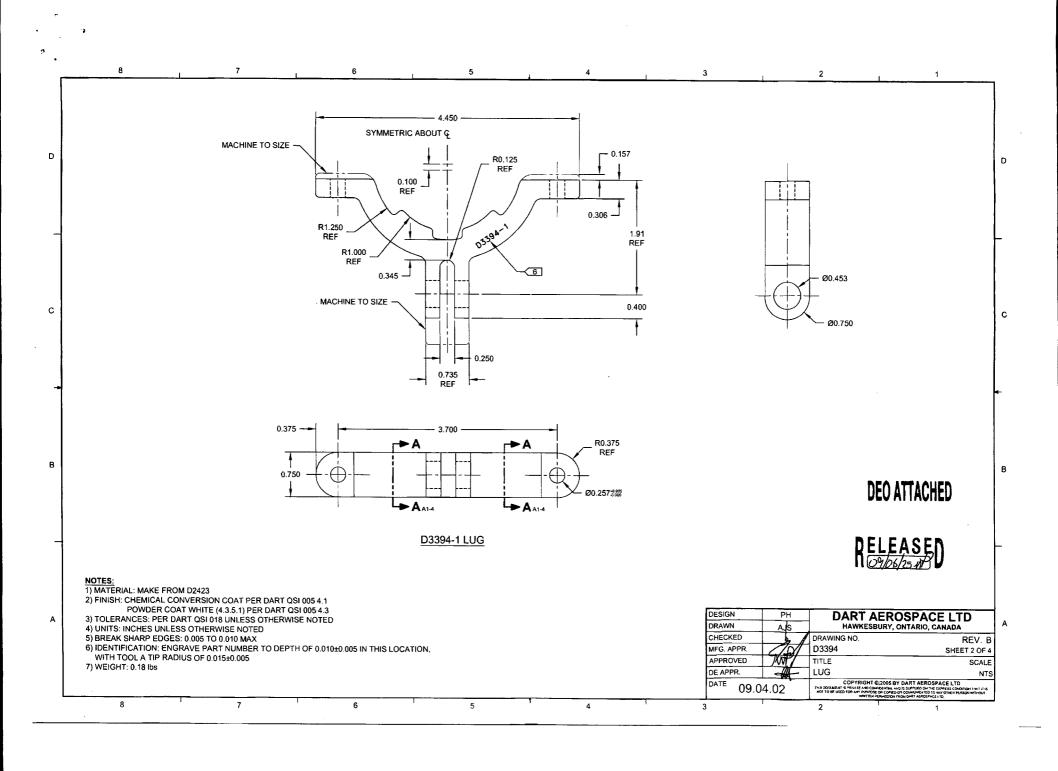
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No				f	216.5426		24	. ,		
D2423 Lug Extrusion									**	CX	14/64	29 =	24
				Location		Loc Q	<u>ty</u>	Loc Code					
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D3301-31	D								**	2.1V		101	つ_

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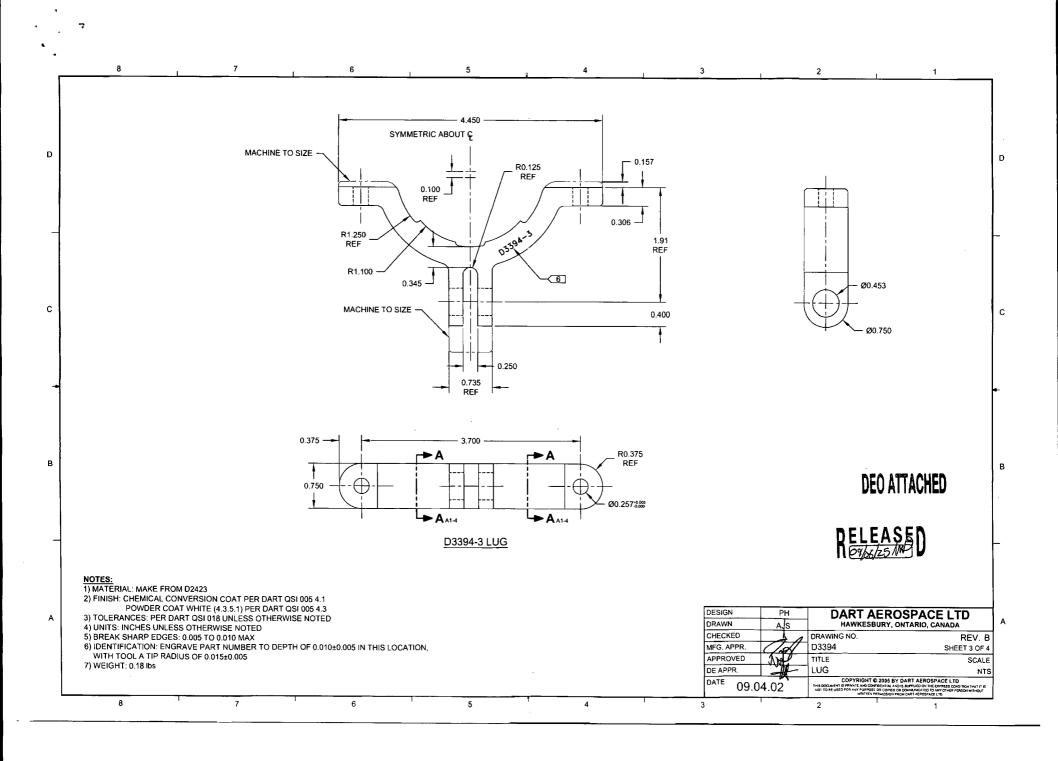
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				MS35489-93 GROMMET			MS35489-93 GROMME	<u> </u>		D I	ELEASEI	1	1
										116	9/64/25 AA))	
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									B ADDED - SEE PAR	045. SHT 4 ADDED FILLET 152	'S IN SECTION A-A.	AJS 09.04.02	1
	NOTES	S :							A NEW ISS	UE		PH 05.02.14	1
	1) MAT	ERIAL: N/	4						DESIGN	DESCRIPTION DA	RT AEROSP	ACF LTD	1
Α	3) TOL			RT QSI 018 UNLESS OTHERWISE NOTE)				DRAWN CHECKED	A#S HA	WKESBURY, ONTAR	IO, CANADA	A
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	6) IDE 7) WE	NTIFICATI IGHT: 0.20	ON: N/A Ibs APPRO	ox ·		•			APPROVED	NO TITLE		SCALE	1
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		ρ.		7		c		 	DATE 09.04	.UZ THIS DOCUMENT S AM	VATE AND CONTROPITINI, AND IS SUPPLIED ANY PURPOSE OR COPPED OR COMMUNIC WRITTEN PERMISSION FROM DART AS	OUR THE EXPRESS CONDITION THAT IT IS ATED TO ANY DIVER PERSON WITHOUT ROSPACE LTD]

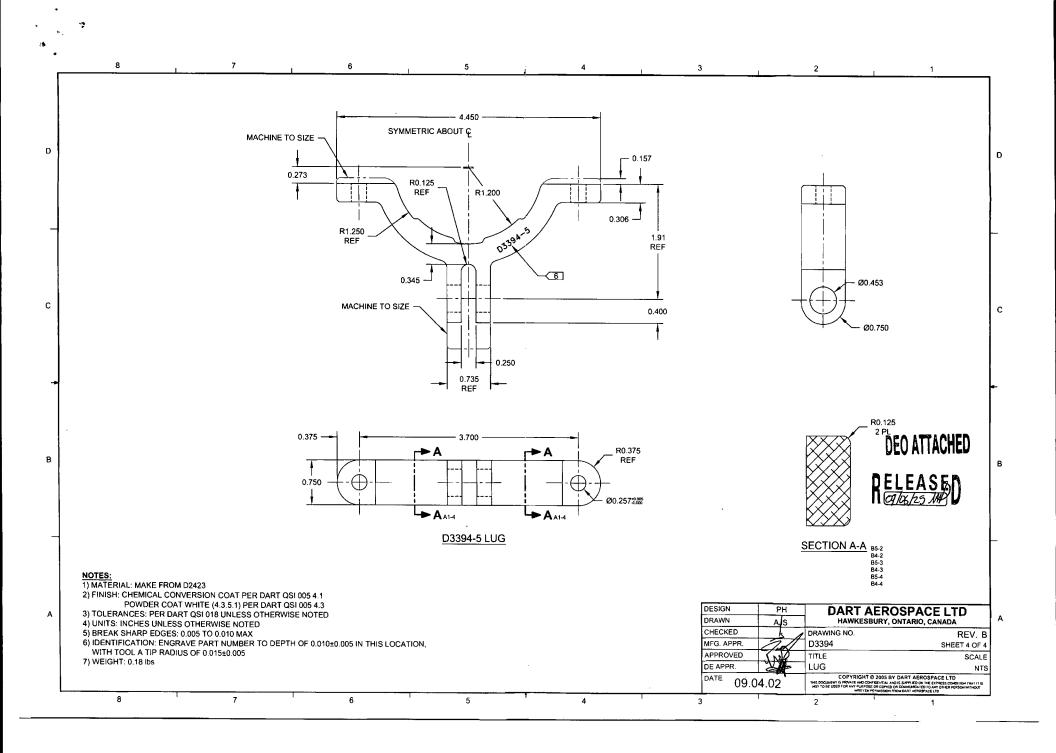
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					Rework			Skid-tube	Crosstube]	Water Jet	Enginee	ring
Part N	lo				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Qua	ality
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	Bending			_	Bend		4	rogram		╙	Outside Dim	ensions	Pressure/F	orced
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	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			_	Part Incorre		Temperatu	ire/Cure
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	Cuffs			<u> </u>	Contamination	<u> </u>	4	ions Incomplete/U	Jnclear	L	Part Moved		Wrong Sto	ck Pulled
	Crushing			<u> </u>	Countersink		-	ned/off center		L	Positioned V		_	
	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge	Other	
	Inspectio	-	Tube	<u> </u>	Drawing	<u> </u>	Misread	i						
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Part N	10.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
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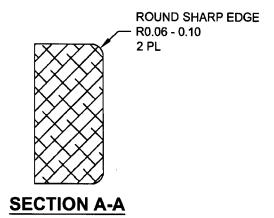


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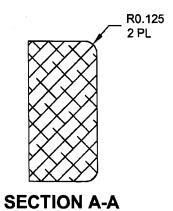
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SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

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WAS:



RELEASED 2009 -11- 25

REASON: DRAFTING ERROR

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DQA: Date:			- · · · · · · · · · · · · · · · · · · ·											
		5.			WORK ORDER NON-	-CC	ONFO	RMANCE / U						AEROSPACE
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						FA	ULT CA	regory				· · · · · · · · · · · · · · · · · · ·		
Landii	ng Gear			, -	General		1		,		1	_		
	Bendi	_			Bend	<u></u>	1	rogram			Outside Dim		-	Pressure/Forced
	_	Not Conce	entric		BOM/Route	L	Grain				Over/Under	—	=	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			-	Part Incorre	⊢	-	Temperature/Cure
		/Kink/Rippl	e/Wave	_	Burrs		1	ion Incomplete/Ui	*	-	Part Lost/Mi	· · ·	-	Weld
	Cuffs				Contamination	<u></u>	4	ions Incomplete/	Unclear		Part Moved	`		Wrong Stock Pulled
	Crushi	•		<u> </u>	Countersink	<u></u>	4 "	ned/off center		-	Positioned V	_		·
	Heat 1			<u> </u>	Cut Too Short		Mislabe				Power Loss/	Surge		Other
1		tion Strip it	n Tube		Drawing		Misrea				••••			
		/Chatter			Drill Holes		Off-set							
•	_	g Sequence		<u> </u>	Finish		4	Calibration						
	Wave,	Twist in Tu	be		Fit/Function		Out of	Sequence						

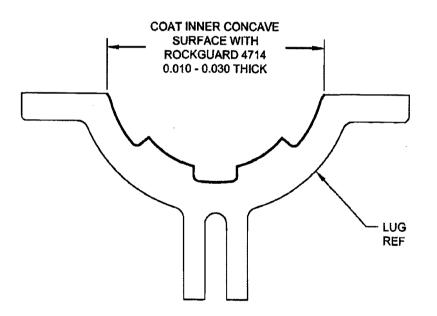
DRAWING	NO. TITLE	REV. B	DART AEROSPACE US	A. INC D.E.O. NO.	SHEET NO.	SCALE
D3394	LUG		ENGINEERING ORD		SHEET 1 OF 1	NTS
DRAWN	<u>q</u>	CHECKED SC	MFG. APPR.	APPROVED N	DE APPR.	
DATE	11.05.02	DATE 11.05.09	DATE //.05.08	DATE 11.05.08	DATE 11.05.09	

PURPOSE

ADD D3394-xRG OPTION

CHANGE

D3394-xRG MOUNTING LUGS ARE INDENTICAL TO D3394-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.





D3394-1RG LUG (SHOWN)
D3394-3RG/-5RG LUGS (SIMILAR)
D3394-041RG/-043RG/-045RG LUG ASSEMBLIES (SIMILAR)

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DQA:		Date:						_				DART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPD		Vork Order ı	indate only - [AEROSPACE
		Dute.									, ,	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS	
					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo				Scrap			Machining	Small Fab	Pr	od. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/St	ore/Packaging	Other
NCR No.					Suspected Unapproved			Large Fab (Composite	_	Supplier	
04		ī		D	.:			A -4:		C: 0		
Root	Date	Ston	Otv	Desci	ription of work order update or non-conformance		Initial	Action		Sign &	Verification	OC Inspector
Cause Design	Date	Step	Qty		or non-conformance	Cn	ief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling	_											
Handling/Pre	_											
Material	\neg											
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved												·
						FA	ULT CAT	TEGORY				
Landir	ng Gear				General		٦		- -	_	_	_
	Bending				Bend	_	1	rogram	-	Outside Di		Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route	<u> </u>	Grain				r tolerance	Set-up
	Cracks			\vdash	Broken/Damage/Defect	_	Hardwa			Part Incorr	} ~	Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave	\vdash	Burrs	_	1 '	ion Incomplete/Unqu	<u> </u>	Part Lost/N	· · · · · · · · · · · · · · · · · · ·	Weld
	Cuffs			\vdash	Countamination	<u> </u>	-	ions Incomplete/Unc	lear	Part Move	L	Wrong Stock Pulled
ļ	Crushing Heat Trea			\vdash	Countersink	H	1	gned/off center	-	Positioned	· · · · · ·	Other
	Inspectio		Tubo	\vdash	Cut Too Short Drawing		Mislabe Misread		L	Power Loss	s/surge [Other
	Marks/Ch	•	rube	-	Drill Holes		Off-set					
	Turning S				Finish	\vdash	-1	Calibration				
₩	Wave/Tw	-		-	Fit/Function	\vdash	4	Sequence				
~	1 3 3 3 7 1 1 1				1		10000					



20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0 , Canada Tel: (613) 678-3957

Fax: (613) 678-3956

Delivery Slip No.:

19911

Date:

Mar 18, 2014

Page:

1

Sold to:	Ship to:	
Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Att	art Aerospace Ltd. t. Micheal Gregoire 70 Aberdeen Street awkesbury, Ontario K6A 1K7
Order No.: 23314	Sold By:	Dewar, Eric
Shipped By: your truck	Ship Date:	Mar 18, 2014

	Description	Unit .	Ordered quantity	Shipped	Backorder
(D3394-3 Lug, as per drawing D3394 REV.B	Each	24	/ 24	
	D2731-7 Lug, as per drawing D2731 REV.C	Each	24 /	24	
	The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.		SPI	1.3/0	
	Received by	Thank	you for you	ur order!	



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0 Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 <u>metec@metec.ca</u>

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

K6A 1K7

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
24	D3394-3P	Lug	PO 23314
24	D2731-7P	Lug	PO 23314

MATERIAL: supplied by DART B105422

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, March 18, 2014



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23314

Purchase Order Date 3/11/2014 PO Print Date 3/11/2014

Page Number 1 of 2

Order From:

VC-MET003

Ship To: DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC. 20 TERRY FOX DRIVE PO BOX 781

VANKLEEK HILL, ON K0B 1R0

CA

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: Ship Acct: 613 678 3957

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
	Line Comments		Promise Date	vicasure		
	Delivery Comments				_	
1 1	D3394-3P	Lug	3/24/2014	 24.00	\$18.95	\$454.
	•_/		Yes	Each		
			3/24/2014			
	AS PER DWG D3394 REV. B B114545					
					Line Total:	\$454.
2 1	D2731-7P	Lug	3/24/2014	24.00	\$16.65	\$399.0
		J	Yes	Each		
			3/24/2014			
	AS PER DWG D2731 REV. C B114546					

Line Total:

\$399.0

5014-3-19

Note: